



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

April 16
D205-634-041
Job Sheet 175170



Part No: D205-634-041

Job Qty: 1 ea

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/28/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/13/18	0.00	0.00	Start Up Skidtubes		<i>M66</i>
110	CNC Bend Skidtubes	1 pcs		4/13/18	0.00	0.65	CNC Bend Skidtube		<i>M66</i>
120	Skidtubes	1 pcs		4/14/18	0.00	2.89	Skidtubes-2		<i>M66</i>
130	QC	1 pcs		4/14/18	0.00	0.00	QC5		<i>BE</i>
140	Skidtubes	1 pcs		4/14/18	0.00	2.89	Skidtubes-2		<i>M66</i>
150	QC	1 pcs		4/14/18	0.00	0.00	QC10		<i>38 DAS</i>
160	QC	1 pcs		4/14/18	0.00	0.00	QC5		<i>9-88 38</i>
170	HandFinish	1 pcs		4/14/18	0.00	1.31	HandFinish2		<i>SA 18-04-17</i>
180	Powdercoat	1 pcs		4/14/18	0.00	0.34	Powdercoat1		<i>BE 18-4-19</i>
190	QC	1 pcs		4/14/18	0.00	0.00	QC3		<i>BE 18-4-19</i>
200	HandFinish	1 pcs		4/16/18	0.00	1.31	HandFinish4		<i>BE 18-4-19</i>
210	QC	1 pcs		4/16/18	0.00	0.00	QC5		<i>38</i>
215	DC	1 pcs		4/16/18	0.00	0.00	DC		<i>9-88</i>
220	Packaging	1 pcs		4/16/18	0.00	0.00	Packaging3-1		<i>DAS</i>
230	QC21-FG	1 Ea		4/16/18	0.00	0.00	QC21		<i>21</i>

Part Op 110 - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe batch in
Descriptions: aft end of tube

120 - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

140 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr *AK 038611*

170 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - START TIME: *11:45* OVEN TEMPERATURE: *320°* FINISH TIME: *12:15* *M138760*

200 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 *M138762* Sikaflex expire date: *11/01* 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 *M138762* Sikaflex expire date: *11/01*

1802 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: *M138761*

210 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

PPP Rev:

Job BOM

Job Allocations

Part Specifications

eunesses.marie

Date: 04/09/18

Part: D205-634-041
Job No: 175170
Serial No/Batch: S059112
Revision: H
Inspector:



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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